

Date: Tuesday, 1/9/2007 4:06:46 PM
 User: Kim Johnston

Process Sheet

Customer	CU-DAR001 Dart Helicopters Services	Drawing Name	SADDLE FITTING, AFT (OUTBOARD/INBOARD)		
Job Number	30215				
Estimate Number	10534				
P.O. Number	N/A	Part Number	D2574		
This Issue	1/9/2007	S.O. No.	N/A		
Prsh Rev.	NC	Drawing Number	D2574 REV E		
First Issue	N/A	Project Number	N/A		
Previous Run	30097	Drawing Revision	E		
Written By		Material	N/A		
Checked & Approved By	<u>DK</u> 02.01.09	Due Date	1/30/2007 Qty: 12 Um: Each		
Comment	Est Rev: I As Per RevE 06-01-27 JLM				

Additional Product

Job Number:



Seq. #:	Machine Or Operation:	Description :		
1.0	D6101005	7075-T7351 8.25X5.0X2.5		
		Comment: Qty.: 1.0000 Each(s)/Unit Total : 12.0000 Each(s) 7075-T7351 8.25X5.0X2.5 Make from D6101-005 billet for D2574 Ensure that grain is along 5.00" length Batch No: <u>B25351</u> x12		<u>E 07/01/09 /SF</u>
2.0	HAAS1	HAAS CNC VERTICAL MACHINING #1		
		Comment: HAAS CNC VERTICAL MACHINING #1 Program Batch No: <u>B30215</u> Double check by: <u>J.F.</u>		
		1-Machine Step No 1 per Folio FA051 and inspect per attached Dimension Sheets 2-Machine Step No 2 per Folio FA051 and inspect per attached Dimension Sheets 3-Machine Step No 3 per Folio FA051 and inspect per attached Dimension Sheets 4-Deburr and remove all machining marks 5-Tumble to remove sharp edges.		<u>Ep/D.F 07/01/18</u>
3.0	MILLING CONV.	CONVENTIONAL MILLING MACHINE		
		Comment: CONVENTIONAL MILLING MACHINE Machine keyway as per dwg D2573 & D2574		<u>J.F 07/01/18</u>
4.0	QC2	INSPECT PARTS AS THEY COME OFF MACHINE		
		Comment: INSPECT PARTS AS THEY COME OFF MACHINE		<u>Ep/D.F 07/01/18</u>

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA:  Date: 07/01/25
 QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Date: Tuesday, 1/9/2007 4:06:47 PM
User: Kim Johnston

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: SADDLE FITTING, AFT (OUTBOARD/INBOARD)

Job Number: 30215

Part Number: D2574

Job Number:



Seq. #: Machine Or Operation:

Description :

5.0 QC8 SECOND CHECK



Comment: SECOND CHECK

mkl 07/01/22 12

6.0 HAND FINISHING1 HAND FINISHING RESOURCE #1



Comment: HAND FINISHING RESOURCE #1

Acid etch and Alodine as per QSI 005 4.1

gsl /

07/01/22 12

7.0 POWDER COATING POWDER COATING



M103141

12X

Comment: POWDER COATING

Powder Coat White Gloss (Ref: 4.3.5.1) as per QSI 005 4.3

m.kl/gsl /

07/01/24

8.0 QC3 INSPECT POWDER COAT/CHEMICAL CONVERSION



Comment: INSPECT POWDER COAT

07/01/24

9.0 PACKAGING 1 PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and Stock

Location: 344

EP09/01/24(12)

07/01/24

12

10.0 QC21 FINAL INSPECTION/W/O RELEASE



Comment: FINAL INSPECTION/W/O RELEASE

07/01/25

Job Completion



N 07-01-25

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

DART AEROSPACE LTD				Work Order: 30215	
Description: Saddle, Aft Inboard				Part Number: D2574	
Inspection Dwg: D2574 Rev. E				Page 1 of 1	

Inspect dimensions highlighted on inspection sheet drawing D2574 Rev. E and record below:

Dim	Min	Max	Go/No Go Gauge	Recorded Actual Dimensions				By	Date
				1	2	3	4		
A	0.438	0.443	DT8682	.440	.439	.440	.439		
B	1.745	1.755		1.752	1.752	1.753	1.752		
C	3.495	3.505		3.500	3.500	3.500	3.500		
D	1.745	1.755		1.752	1.752	1.753	1.752		
E	7.990	8.010		7.999	8.004	8.000	8.004		
F	0.490	0.510		.493	.493	.491	.493		
G	0.257	0.262	DT8683	.259	.260	.258	.258		
H	0.375	0.380	DT8684	.376	.376	.376	.376		
I	0.490	0.510		.500	.500	.495	.500		
J	1.174	1.184		1.181	1.181	1.180	1.180		
K	0.558	0.578		.572	.572	.572	.572		
L	1.174	1.184		1.181	1.181	1.180	1.180		
M	1.365	1.375		1.373	1.370	1.370	1.370		
N	2.495	2.505		2.500	2.500	2.500	2.500		
O	4.119	4.129		4.126	4.126	4.126	4.125		
P	0.115	0.135		.126	.126	.125	.124		
Q	0.115	0.135		.135	.135	.135	.132		
R	0.240	0.260		.254	.254	.254	.256		
S	0.115	0.135		.124	.124	.124	.125		
T	0.178	0.198		R.188	R.188	R.188	R.188		
U	3.210	3.250		3.233	3.233	3.233	3.232		
V	0.230	0.250		.242	.242	.242	.250		
W	0.115	0.135		.125	.128	.125	.125		
X	0.307	0.312		.310	.310	.312	.310		
Y	0.760	0.765		.760	.760	.763	.760		
Z	0.352	0.372		.363	.363	.367	.363		
AA	0.470	0.530		R.500	R.500	R.500	R.500		
AB	0.615	0.635		.618	.625	.629	.628		
AC	0.053	0.073		R.063	.063	R.063	.063		
AD	0.240	0.260		.252	.252	.251	.252		
AE	1.500	1.520		1.512	1.510	1.510	1.506		
AF	0.115	0.135		.135	.135	.125	.125		
AG	0.240	0.280		.253	.253	.253	.253		
AH	0.240	0.260		.252	.252	.255	.251		
AI	2.000	2.020		2.000	2.000	2.000	2.000		
AJ	0.023	0.043		.025	.025	.025	.025		

Accept/Reject

Measured by:	J.F. /58
Date:	07/01/18

Audited by:	CMR
Date:	07/01/22

Rev	Date	Change	Revised by	Approved
A		New Issue	RF	
B	02.09.27	Re-format; Added Rev. D	KJ	
C	02.10.11	Re-format; Added DT8682, DT8683, DT8684	KJ	
D	05.05.05	Added dimension AI	KJ/RF	
E	05.12.05	Added dimension AJ	KJ/JLM	JK JLM

DART AEROSPACE LTD				Work Order: 30215	
Description: Saddle, Aft Inboard				Part Number: D2574	
Inspection Dwg: D2574 Rev. E				Page 1 of 1	

Inspect dimensions highlighted on inspection sheet drawing D2574 Rev. E and record below:

				Recorded Actual Dimensions					
Dim	Min	Max	Go/No Go Gauge	1	2	3	4	By	Date
A	0.438	0.443	DT8682	.440"	.440"	.440"	.440"		
B	1.745	1.755		1.75"	1.75"	1.75"	1.75"		
C	3.495	3.505		3.500	3.500"	3.500"	3.500"		
D	1.745	1.755		1.751"	1.751"	1.751"	1.751"		
E	7.990	8.010		8.001"	8.002"	8.002"	8.000"		
F	0.490	0.510		.498"	.499"	.496"	.496"		
G	0.257	0.262	DT8683	.260"	.260"	.260"	.260"		
H	0.375	0.380	DT8684	.376"	.376"	.376"	.376"		
I	0.490	0.510		.499"	.500"	.499"	.501"		
J	1.174	1.184		1.181"	1.181"	1.181"	1.181"		
K	0.558	0.578		.568"	.567"	.568"	.570"		
L	1.174	1.184		1.181"	1.181"	1.181"	1.181"		
M	1.365	1.375		1.372"	1.372"	1.372"	1.372"		
N	2.495	2.505		2.500"	2.500"	2.500"	2.500"		
O	4.119	4.129		4.124"	4.124"	4.124"	4.124"		
P	0.115	0.135		.124"	.125"	.126"	.127"		
Q	0.115	0.135		.135"	.135"	.135"	.135"		
R	0.240	0.260		.253"	.254"	.256"	.256"		
S	0.115	0.135		.123"	.123"	.123"	.123"		
T	0.178	0.198		.188"	.188"	.188"	.188"		
U	3.210	3.250		3.233"	3.233"	3.233"	3.233"		
V	0.230	0.250		.237"	.239"	.237"	.237"		
W	0.115	0.135		.131"	.131"	.130"	.122"		
X	0.307	0.312		.312"	.312"	.312"	.312"		
Y	0.760	0.765		.762"	.763"	.763"	.763"		
Z	0.352	0.372		.365"	.370"	.370"	.370"		
AA	0.470	0.530		R.500"	R.500"	R.500"	R.500"		
AB	0.615	0.635		.627"	.627"	.626"	.627"		
AC	0.053	0.073		R.063"	R.063"	R.063"	R.063"		
AD	0.240	0.260		.249"	.254"	.251"	.249"		
AE	1.500	1.520		1.504"	1.512"	1.512"	1.512"		
AF	0.115	0.135		.135"	.135"	.135"	.135"		
AG	0.240	0.280		.255"	.256"	.265"	.265"		
AH	0.240	0.260		.251"	.256"	.251"	.250"		
AI	2.000	2.020		2.004"	2.007"	2.004"	2.004"		
AJ	0.023	0.043		.025	.025"	.025"	.025"		

Accept/Reject

Measured by:	J.F.	Audited by:	<i>mk</i>
Date:	07/01/19	Date:	07/01/22

Rev	Date	Change	Revised by	Approved
A		New Issue	RF	
B	02.09.27	Re-format; Added Rev. D	KJ	
C	02.10.11	Re-format; Added DT8682, DT8683, DT8684	KJ	
D	05.05.05	Added dimension AI	KJ/RF	
E	05.12.05	Added dimension AJ	KJ/JLM <i>JK</i> <i>ad</i>	

DART AEROSPACE LTD				Work Order: 30215	
Description: Saddle, Aft Inboard				Part Number: D2574	
Inspection Dwg: D2574 Rev. E				Page 1 of 1	

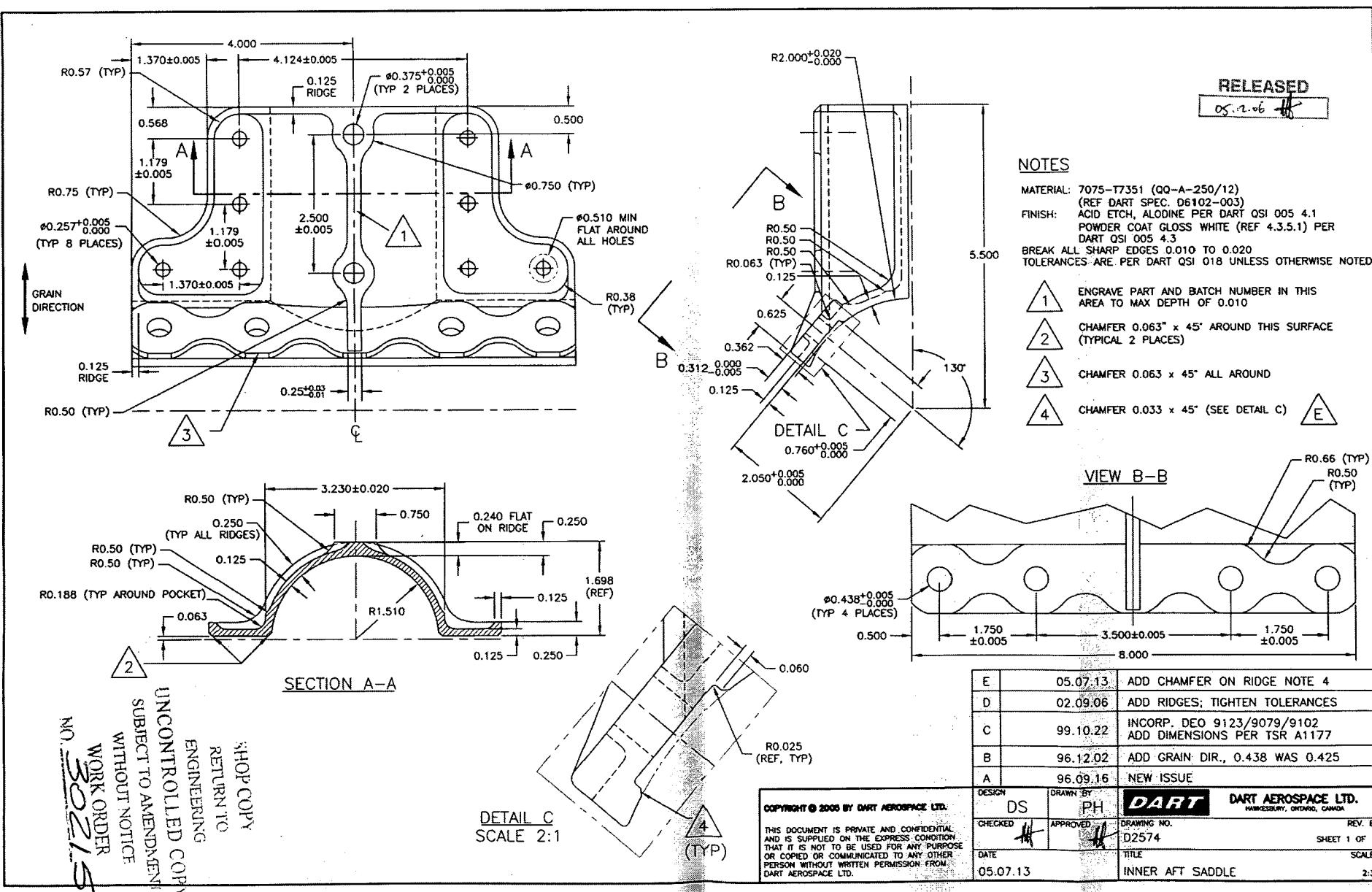
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				1	2	3	4		
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B	1.745	1.755		1.750	1.751	1.751	1.751		
C	3.495	3.505		3.500	3.501	3.501	3.501		
D	1.745	1.755		1.751	1.750	1.750	1.750		
E	7.990	8.010		8.003	8.002	8.002	8.002		
F	0.490	0.510		.496	.496	.497	.497		
G	0.257	0.262	DT8683	.254	.258	.258	.258		
H	0.375	0.380	DT8684	.376	.376	.376	.377		
I	0.490	0.510		.505	.505	.505	.506		
J	1.174	1.184		1.179	1.179	1.180	1.181		
K	0.558	0.578		.570	.570	.570	.570		
L	1.174	1.184		1.179	1.179	1.179	1.180		
M	1.365	1.375		1.370	1.370	1.370	1.370		
N	2.495	2.505		2.500	2.500	2.500	2.501		
O	4.119	4.129		4.127	4.127	4.122	4.123		
P	0.115	0.135		.126	.126	.126	.126		
Q	0.115	0.135		.126	.126	.126	.125		
R	0.240	0.260		.253	.253	.252	.253		
S	0.115	0.135		.120	.120	.121	.125		
T	0.178	0.198		.188	.188	.188	.189		
U	3.210	3.250		3.228	3.228	3.228	3.228		
V	0.230	0.250		.250	.250	.250	.250		
W	0.115	0.135		.120	.120	.120	.121		
X	0.307	0.312		.310	.310	.311	.312		
Y	0.760	0.765		.760	.760	.762	.762		
Z	0.352	0.372		.362	.363	.363	.363		
AA	0.470	0.530		.500	.500	.500	.500		
AB	0.615	0.635		.625	.625	.617	.617		
AC	0.053	0.073		.063	.063	.063	.063		
AD	0.240	0.260		.250	.255	.255	.255		
AE	1.500	1.520		1.512"	1.512"	1.511	1.512		
AF	0.115	0.135		.120	.125	.125	.120		
AG	0.240	0.280		.250	.255	.255	.255		
AH	0.240	0.260		.250	.255	.255	.255		
AI	2.000	2.020		.2002	.2002	.2002	.2002		
AJ	0.023	0.043		.031	.037	.037	.037		
Accept/Reject									

Measured by:	J-F. 18/F	Audited by:	On
Date:	07/01/22	Date:	07/01/22

Rev	Date	Change	Revised by	Approved
A		New Issue	RF	
B	02.09.27	Re-format; Added Rev. D	KJ	
C	02.10.11	Re-format; Added DT8682, DT8683, DT8684	KJ	
D	05.05.05	Added dimension AI	KJ/RF	
E	05.12.05	Added dimension AJ	KJ/JLM	JLM





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SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK ORDER
NO. 30215

